



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3197-041
Job Sheet 168506



Part No: D3197-041

Job Qty: 4 ea

Part Name: Bar



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/15/17

Job Tracking No:

Due Date: 12/15/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV B IPP Rev: A New Issue 05-11-08 JLM IPP Rev: B As per Rev B 06-03-10 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	4 Ea		12/14/17	0.00	0.00	Start Up Machining		
100	Bandsaw	4 pcs		12/14/17	0.00	0.35	Bandsaw1		
110	CNC Vertical Machining	4 pcs		12/14/17	0.51	2.96	HAAS 1		
120	QC	4 pcs		12/14/17	0.00	0.00	QC2		
130	Lathe Conv	4 pcs		12/14/17	0.00	0.70	Lathe Conv-1		
140	QC	4 pcs		12/14/17	0.00	0.00	QC8		
150	HandFinish	4 pcs		12/14/17	0.00	0.34	HandFinish1		
160	Powdercoat	4 pcs		12/14/17	0.00	0.17	Powdercoat3		
170	QC	4 pcs		12/14/17	0.00	0.00	QC3		
180	Small Fab	4 pcs		12/15/17	0.00	1.02	Small Fab		
190	QC	4 pcs		12/15/17	0.00	0.00	QC5		
200	Packaging	4 pcs		12/15/17	0.00	0.00	Packaging3		
210	QC21-SA	4 Ea		12/15/17	0.00	0.00	QC21		

Part Op 100 - Cut blanks: 29.125" long

Descriptions: 110 - 1-Face ends to length per dwg D3197 2-Machine D3197-1 as per Folio FA340 and Dwg D3197

130 - Chamfer as per Dwg D3197

160 - START TIME: 8:50 OUT 3:00 FINISH 9:20 M 126370

180 - Assemble D3197-041 as per Dwg D3197

Job Allocations

Operation		Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	ST 279	MS27039-1-24 PH 134537-108	8	34	0	0
180-Small Fab	ST009	D2690-5 SO 11322	8	10	0	0
	GA	D3242-1 SO 19183	8	13	0	0
	GA	D3489-3-200 SO 09962	8	27	0	0
	SD 19466	M7075T73R1.000	10	5	0	0
	ST 303	MS21042L3 SO 16501	8	1,139	0	0
	ST 2638	NAS1149D0363J SO 18269	24	445	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		Skid- Machi Thermofori Large		AGAINST DEPARTMENT/PROCESS						
Date : _____		Step #: _____		QTY: _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Mfg Date: 12/11/17 Job No: 168506 D3197 - 041 Start up Operation						
Description Work Order Deviation												
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; border-right: 1px solid black;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; border-right: 1px solid black;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Temperature ☐ Set-up ☐ BOM/Route ☐ Broken/Dam. ☐ Inspection In ☐ Contaminat ☐ Countersink ☐ Cut Too Short ☐ Instructions I ☐ Drill Holes ☐ </td> </tr> </table>		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature ☐ Set-up ☐ BOM/Route ☐ Broken/Dam. ☐ Inspection In ☐ Contaminat ☐ Countersink ☐ Cut Too Short ☐ Instructions I ☐ Drill Holes ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%; border-right: 1px solid black;"> Misaligned/off center ☐ </td> <td style="width:33%; border-right: 1px solid black;"> Turning Sequence ☐ </td> <td style="width:33%;"> d Wrong)imensions ler tolerance rrect /Missing ed </td> </tr> </table>		Misaligned/off center ☐	Turning Sequence ☐	d Wrong)imensions ler tolerance rrect /Missing ed
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐											
Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature ☐ Set-up ☐ BOM/Route ☐ Broken/Dam. ☐ Inspection In ☐ Contaminat ☐ Countersink ☐ Cut Too Short ☐ Instructions I ☐ Drill Holes ☐											
Misaligned/off center ☐	Turning Sequence ☐	d Wrong)imensions ler tolerance rrect /Missing ed										
		OTHER :										

DART AEROSPACE LTD		Work Order:	168506
Description: Bar		Part Number:	D3197-1
Inspection Dwg: D3197 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	/		M-Tape	
25.06	+/-0.030	25.06	/		M-Tape	
11.44	+/-0.030	11.44	/		M-Tape	
0.500	+/-0.010	0.500	/		Vern Mlob	
0.250	+/-0.030	0.250	/		Vern Mlob	
Ø0.219	+0.005/-0.000	0.219	/		Gage Pin	
Ø0.191	+0.005/-0.000	0.192	/		Gage Pin	
1.000	+/-0.005	0.998	/		Vern Mlob	
2.69	+/-0.030	2.688	/		Vern Mlob	
1.000	+/-0.010	0.999	/		Vern Mlob	
0.300	+/-0.010	0.300	/		Vern Mlob	
0.063 x 45°	+/-0.010	0.062	/		Vern Mlob	
Ø1.000	+/-0.010	0.999	/		Vern Mlob	

Measured by: FM/mf	Audited by: B.F.	Prototype Approval:	N/A
Date: 17-12-10	Date: 17-12-12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3197-041)	KJ/JLM	
B	07.03.09	Dwg revision update	KJ/JLM	BE